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647.0112
Job Sheet 176235



Part No: 647.0112

Job Qty: 50 ea **DAS**
60 21
9-80

Part Name: Strut Bracket



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/19/18

Job Tracking No:

Due Date: 4/27/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG 647.0100 REV.B SHEET 3 IPP REV:A 12.08.14 NEW ISSUE DD VERF:JFS IPP REV:B 18.02.08 AS
PER DWG REV.B DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	50 Ea	4/27/18	4/27/18	0.00	0.00	Start Up Waterjet		α 18/04/21
100	Waterjet	50 pcs	4/27/18	4/27/18	0.00	1.96	Waterjet1		α 18/04/21
110	QC	50 pcs	4/27/18	4/27/18	0.00	0.00	QC2 Waterjet-1		α 18/04/21
120	QC	50 pcs	4/27/18	4/27/18	0.00	0.00	QC8-1		38
130	Brake NC	50 pcs	4/27/18	4/27/18	0.00	2.23	Brake NC 1		38
140	QC	50 pcs	4/27/18	4/27/18	0.00	0.00	QC5		38
150	SprayPaint	50 pcs	4/27/18	4/27/18	0.00	1.17	Spray Paint		38
160	QC	50 pcs	4/27/18	4/27/18	0.00	0.00	QC14		38
170	Packaging	50 pcs	4/27/18	4/27/18	0.00	0.00	Packaging3-1		38
180	QC21-SA	50 Ea	4/27/18	4/27/18	0.00	0.00	QC21		38

Part Op 100 - 1-Cut as per Dwg Dwg Rev: **B** Prog Rev: **B** 2-Deburr if necessary

Descriptions: 130 - USE DT9834 FOR FORMING

150 - PRIME AS PER IAW MIL-PRF-23377 TYPE 1 CLASS N PRIME AS PER DWG NOTE 6 BATCH: **138747**

170 - ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S14GA	304SS sheet .080	1.6250 sf (.0325 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M304S14GA	2	25	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Strut Bracket	0.177Inches	+ 0.005 - 0.001	0.182 0.176	
2	Strut Bracket	0.191Inches	+ 0.005 - 0.001	0.196 0.190	
3	Strut Bracket	0.300Inches	± 0.030	0.330 0.270	
4	Strut Bracket	0.900Inches	± 0.030	0.930	

Date: 04/21/18

			0.870
5	Strut Bracket	0.350Inches $\pm$ 0.010	0.360 0.340
6	Strut Bracket	1.500Inches $\pm$ 0.030	1.530 1.470
7	Strut Bracket	1.006Inches $\pm$ 0.030	1.036 0.976
8	Strut Bracket	0.080Inches $\pm$ 0.010	0.090 0.070

Plex 4/19/18 7:45 AM Dart.lajeunesse.marie